

Page 1

Quality Control

Work Order ID 106496

106496

Page 2

September-04-13 9:18:06 AM

Item ID: D3560-4 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Arm
 Start Date: 12/09/2013 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/09/2013 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00				4			SLB-9-10
130									
QC	Memo	0.00							
Quality Control									
210	Identify as per dwg & Stock Location: <u>WMA.003</u>	0.00				4	0		13-09-16
210									
Packaging	Memo	0.00							
Packaging	*** STOCK IN STEP CELL***								
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

MF
13-9-16

Picklist Print

September-04-13 9:18:05 AM

Page 1

Work Order ID: 106496

Parent Item: D3560-4

Start Date: 12/09/2013

Required Date: 12/09/2013

Parent Item Name: Arm

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-10 JLM use-044
REV.F DD VERF:JLM

IPP REV:B 13.06.03 PER DWG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X05.000 6061-T6 Bar .500 x 5.00		Purchased	No				f	59.7050		5.8526316			
										5.200		13-09-04	

Location

Loc Qty

Loc Code

MAT

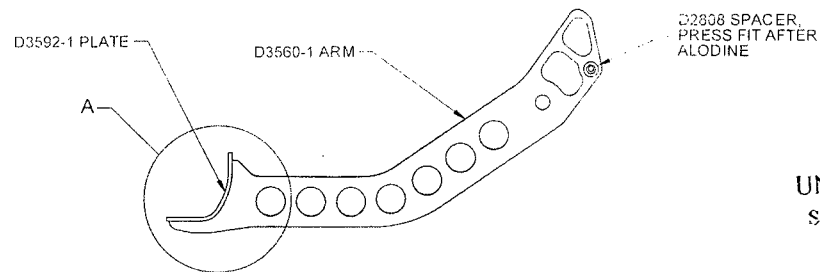
59.705

125592

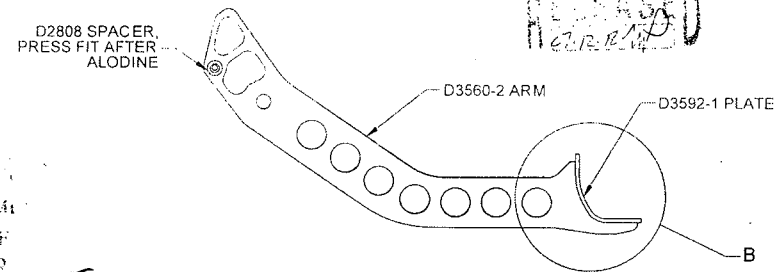
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5.200

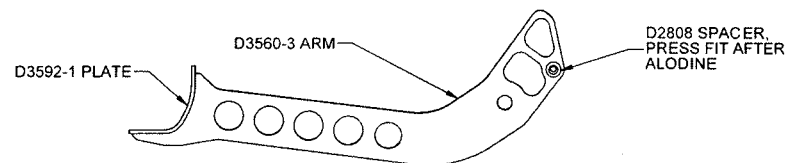
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RECORDED



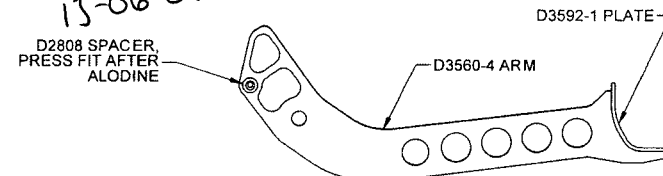
D3560-041 ARM WELDMENT



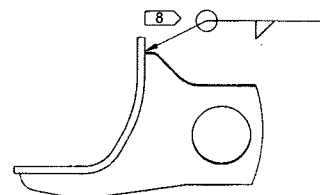
D3560-042 ARM WELDMENT



D3560-043 ARM WELDMENT



D3560-044 ARM WELDMENT



**DETAIL A
SCALE 1 : 2**

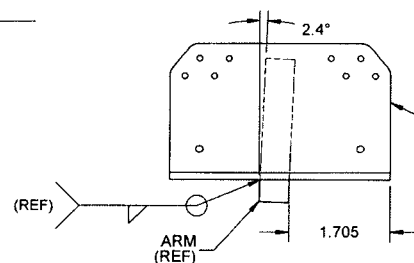
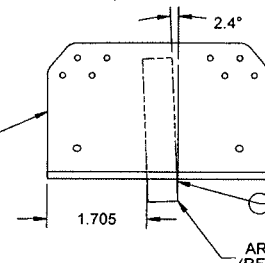
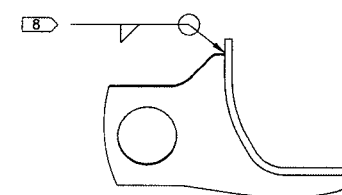


PLATE
(REF)



ARM
(REF)



**DETAIL B
SCALE 1 : 2**

PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.23 lbs (TYP)
- 8) WELDING: PER DART QSI 004

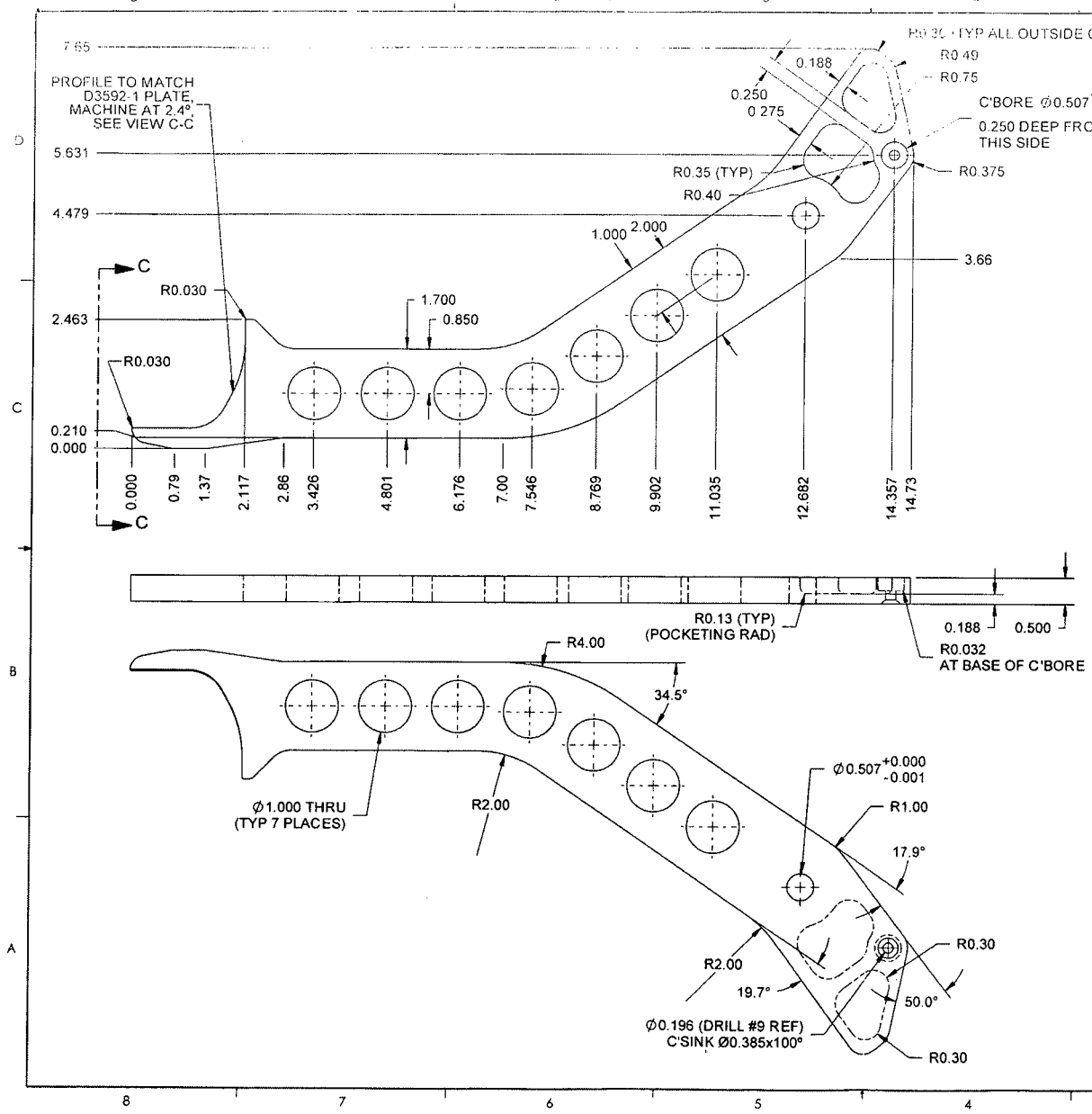
D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.11.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3560** REV. D
SHEET 1 OF 5
TITLE **ARM WELDMENT** SCALE 1:4

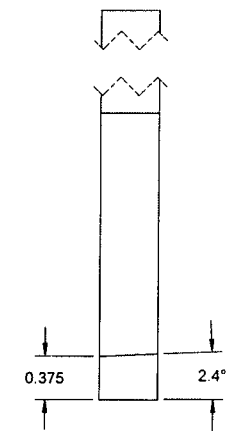
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103699



D3560-1 ARM WELDMENT

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs

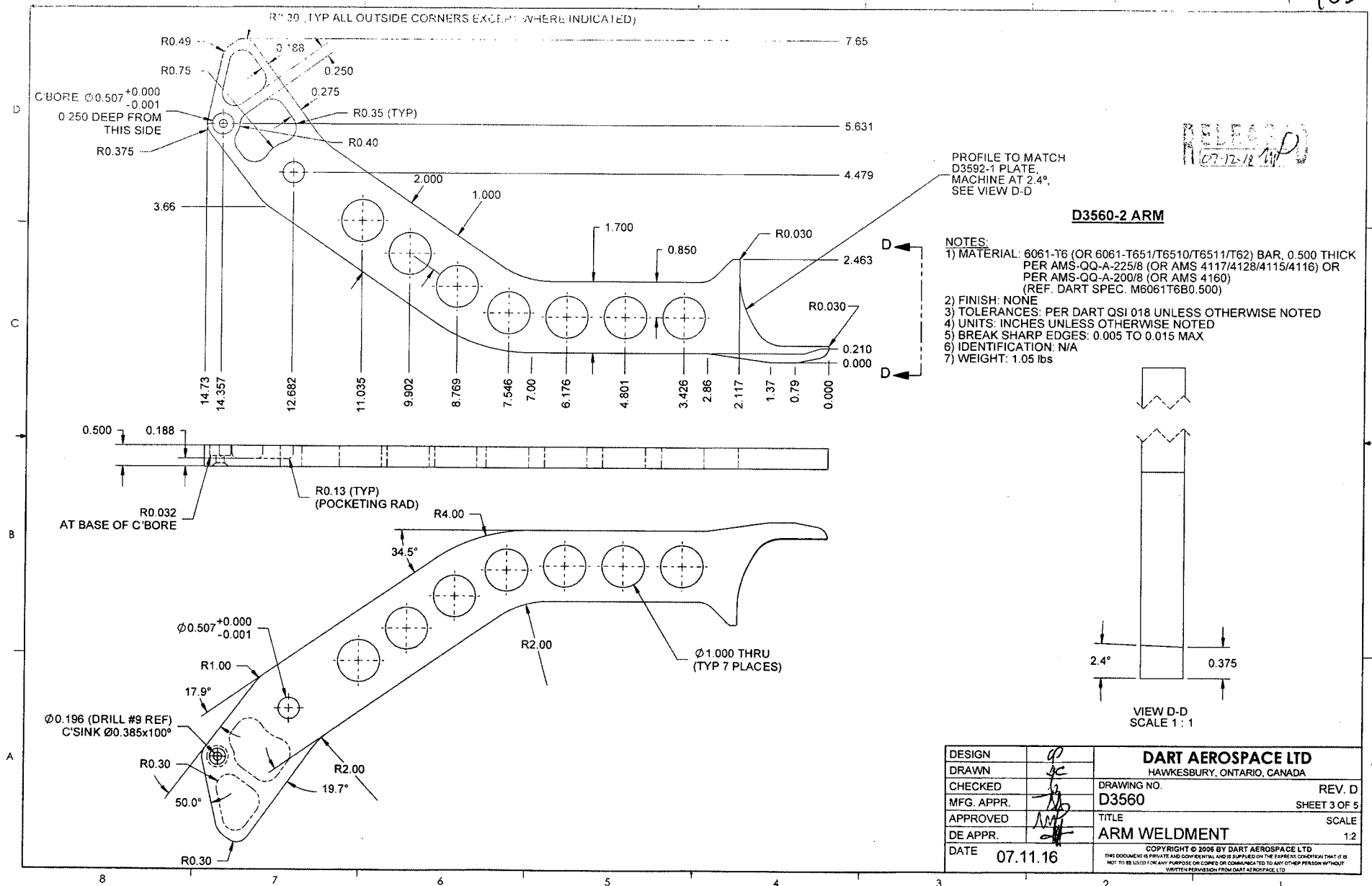


VIEW C-C
SCALE 1:1

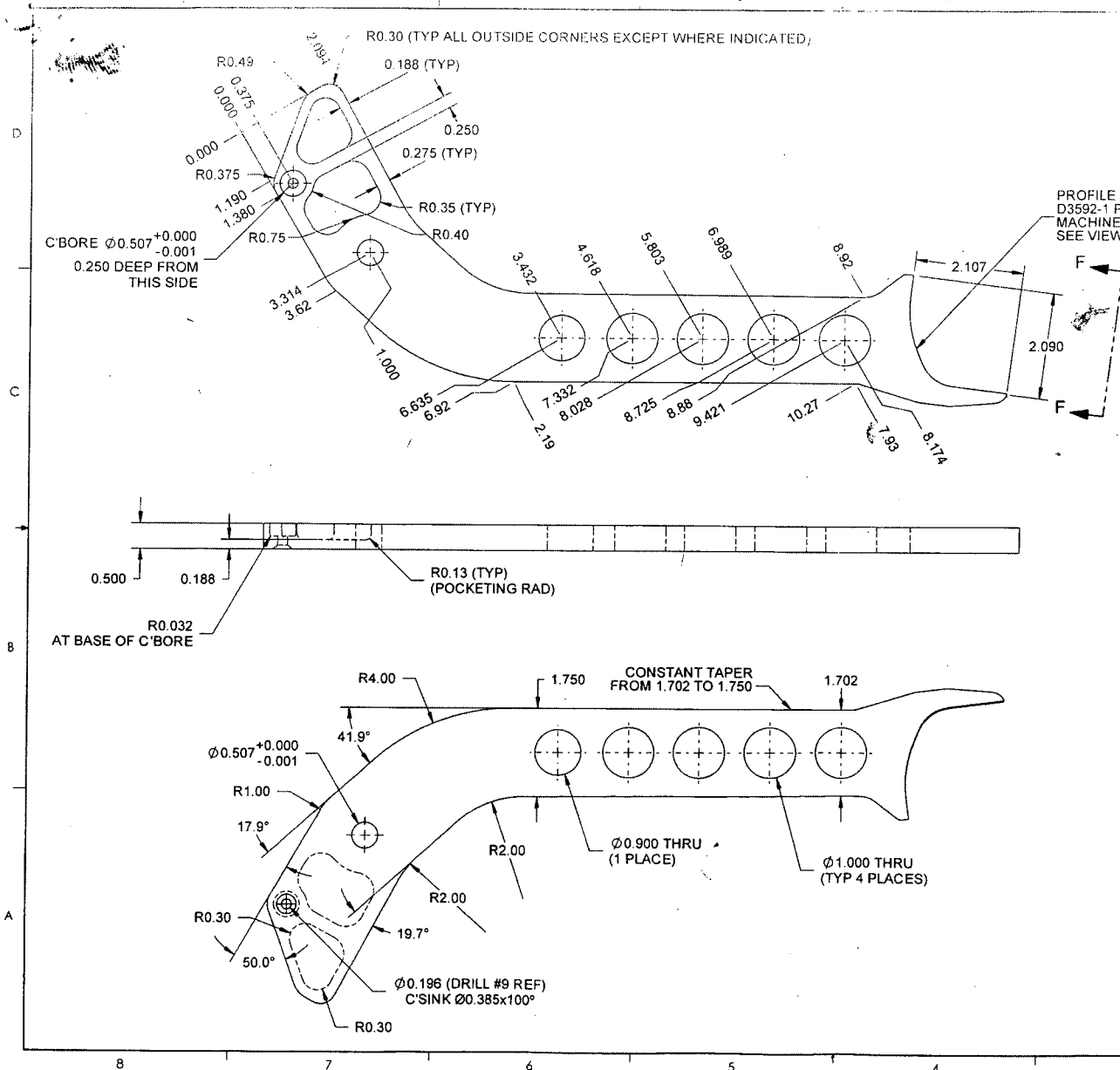
RELEASED
07.12.16

DESIGN	g	DART AEROSPACE LTD	
DRAWN	dc	HAWKESBURY, ONTARIO, CANADA	
CHECKED	g	DRAWING NO.	REV. D
MFG. APPR.	g	D3560	SHEET 2 OF 5
APPROVED	g	TITLE	SCALE
DE APPR.	g	ARM WELDMENT	1:2
DATE	07.11.16	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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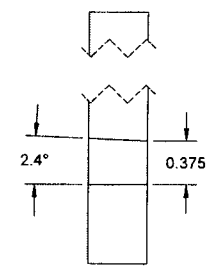
103699



PROFILE TO MATCH
D3592-1 PLATE.
MACHINE AT 2.4°.
SEE VIEW F-F

D3560-4 ARM

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3560	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ARM WELDMENT	1:2
DATE	07.11.16	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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DART AEROSPACE LTD		Work Order: 106 2958
Description: Arm		Part Number: D3560-4
Inspection Dwg: D3560	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	.5065	✓		SL08	Vern
Ø0.196	+0.005/-0.001	.198	✓			
Ø1.000	+0.010/-0.001	1.005	✓			
Ø0.900	+0.010/-0.001	.899	✓			
0.500	+/-0.010	.498	✓			
0.250	+/-0.010	.250	✓			
0.275	+/-0.010	.275	✓			
0.188	+/-0.010	.183	✓			
1.750	+/-0.010	1.750	✓			
1.702	+/-0.010	1.704	✓			
Ø0.385 x 100°	+/-0.010 x 0.5°	0.386/100°	✓		MJP 84	Vern
0.250 Deep	+/-0.010	.253	✓			

Measured by: *[Signature]*
Date: 13-09-04

Audited by: SL
Date: 13-9-10

Prototype Approval: N/A
Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	
C	10.02.02	Dimensions updated per Dwg Rev C	KJ	<i>[Signature]</i>